

Date: Monday, 11/27/2006 4:21:24 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: LUG		
Job Number	: 29710					
Estimate Number	: 11019					
P.O. Number	: N/A		Part Number	: D27313		
This Issue	: 11/27/2006 S.O. No. : N/A		Drawing Number	: D2731 REV B		
Prsht Rev.	: NC		Project Number	: N/A		
First Issue	: N/A		Drawing Revision	: B		
Previous Run	: 27420		Material	: N/A		
Written By	: <u>JK</u> 06/11/27		Due Date	: 12/15/2006 Qty: 50 Um: Each		
Checked & Approved By						
Comment	: Est:D 00.05.19 Added inspect level 8, removed P/O for powder coating EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :				
1.0	D2423	Lug Extrusion				
Comment: Qty.: 0.0717 f(s)/Unit Total : 3.5858 f(s) Lug Extrusion D2423 Batch: B23779			J.G 06/11/2005			
2.0	BAND SAW	BAND SAW				
Comment: BAND SAW Cut D2423 Extrusion: 0.82" Long			J.G 06/11/2005 50			
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1				
Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per folio D2731-3 Check for crack while loading into the machine Tumble Deburr any rough edges after tumbling			J.G 06/11/2005 50			
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE				
Comment: INSPECT PARTS AS THEY COME OFF MACHINE			J.G 06/11/2005 50			
5.0	QC5	SECOND CHECK				
Comment: SECOND CHECK Inspect Level 5			J.G 06/11/2005 50			

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

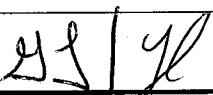
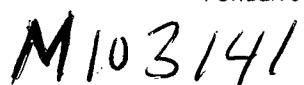
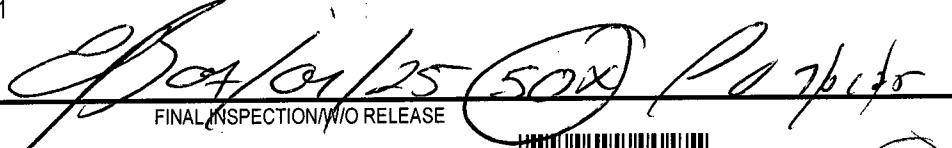
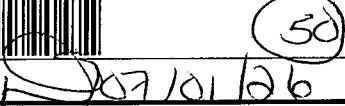
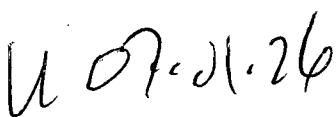
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/01/26
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: LUG
Job Number: 29710		Part Number: D27313
Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 
Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1		 07-01-24 50
7.0	POWDER COATING	POWDER COATING  
Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3		 07/01/25
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION 
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		 50
9.0	PACKAGING 1	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: ST148		 50x
10.0	QC21	FINAL INSPECTION/W/O RELEASE 
Comment: FINAL INSPECTION/W/O RELEASE		 50
Job Completion		 

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	Z9710
Description: Lug	Part Number:	D2731-3
Inspection Dwg: D2731 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

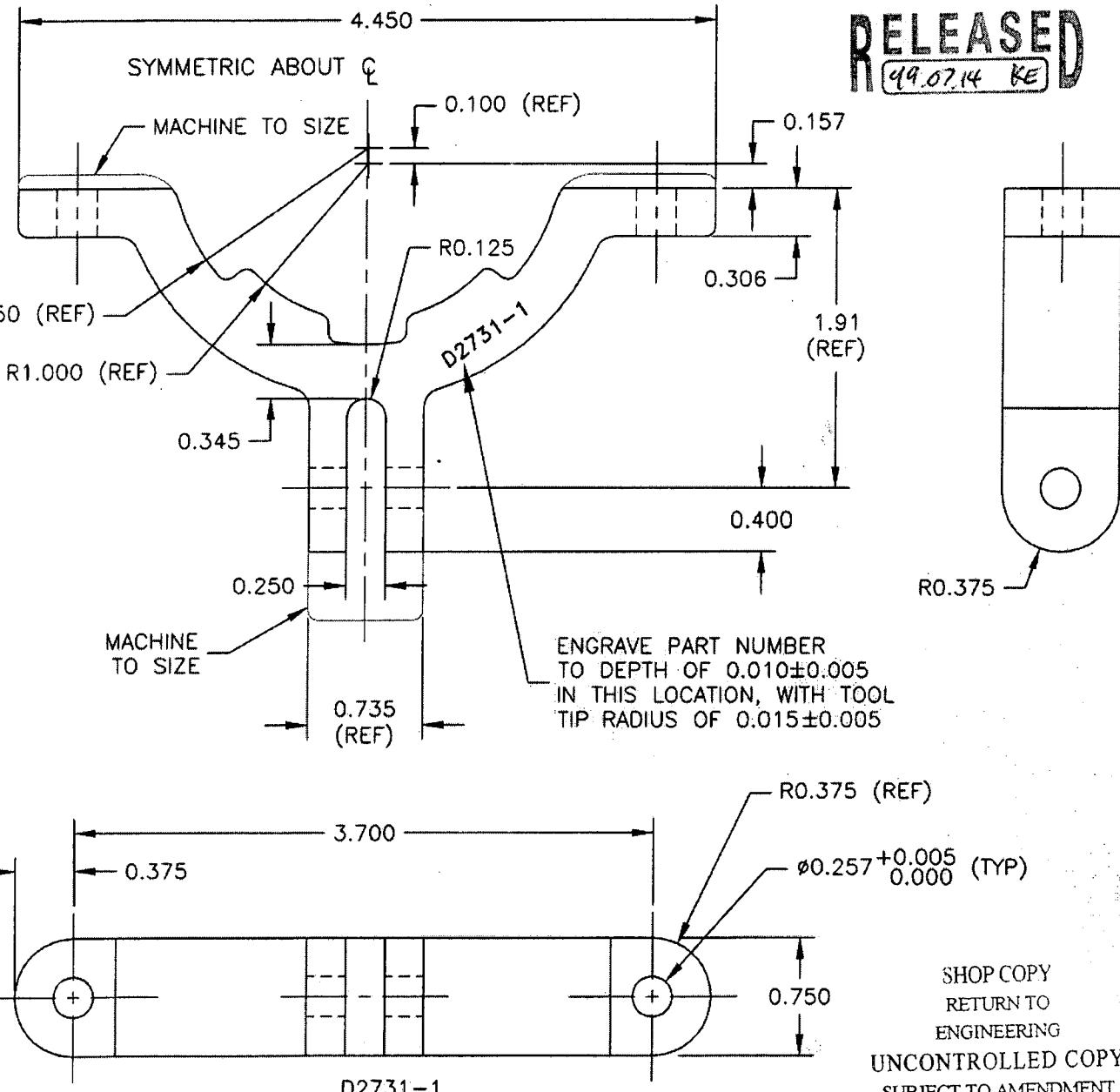
Measured by:		Audited by:		Prototype Approval:	N/A
Date:		Date:		Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.22	New Issue	KJ/RF ✓	✓



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RIGHT

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CHECKED <i>KE</i>	APPROVED <i>JX</i>	DRAWING NO. D2731
DATE 99.07.06		REV. B SHEET 1 OF 4 SCALE 1:1
		TITLE MOUNTING LUG
A	98.05.13	NEW ISSUE
B	99.07.06	REVISED DIMENSIONS

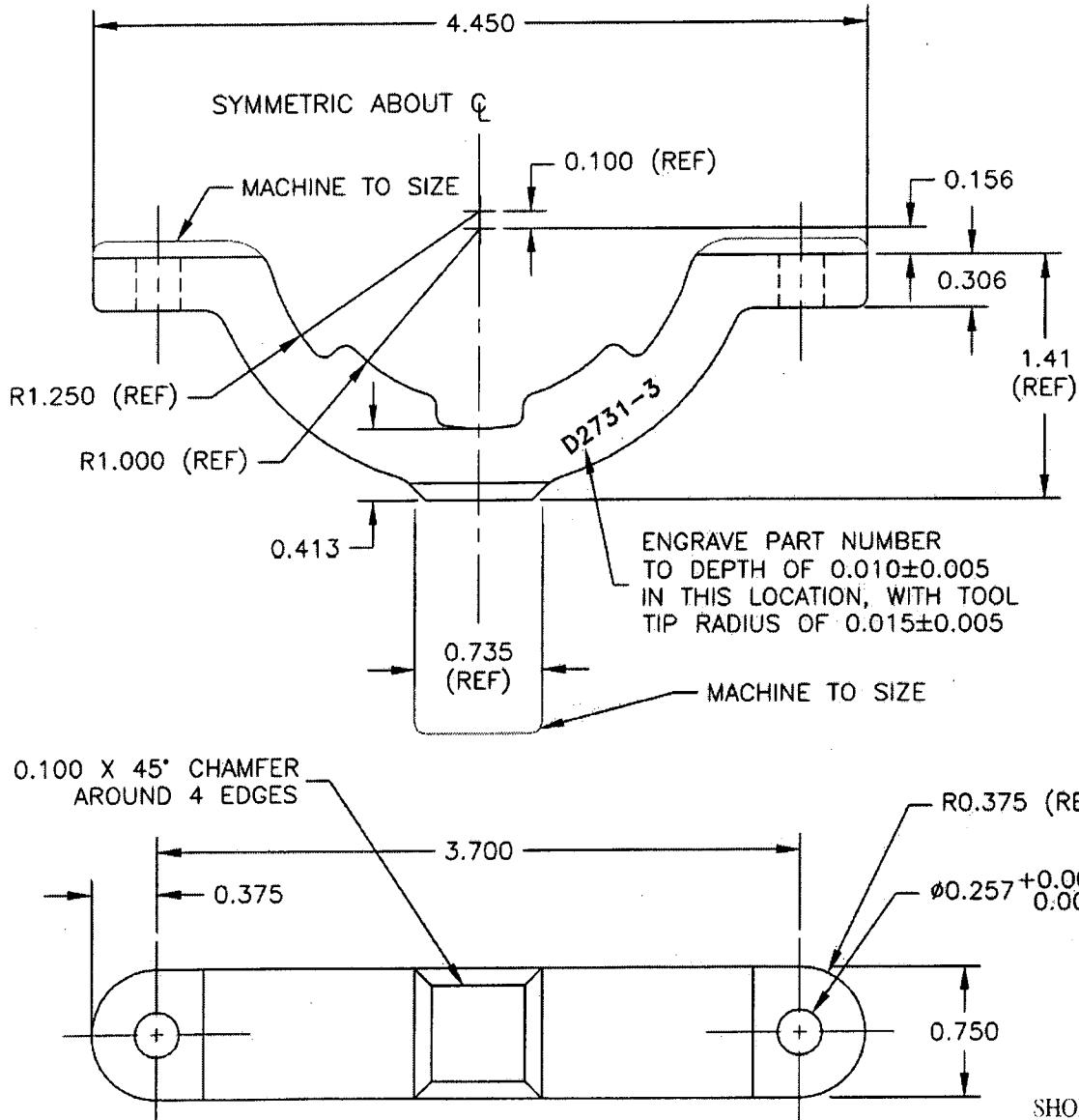


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CHECKED <i>KE</i>	APPROVED <i>JF</i>	DRAWING NO. D2731	REV. B SHEET 2 OF 4
DATE 99.07.06	TITLE MOUNTING LUG		SCALE 1:1

RELEASED
19.07.14 RE



MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

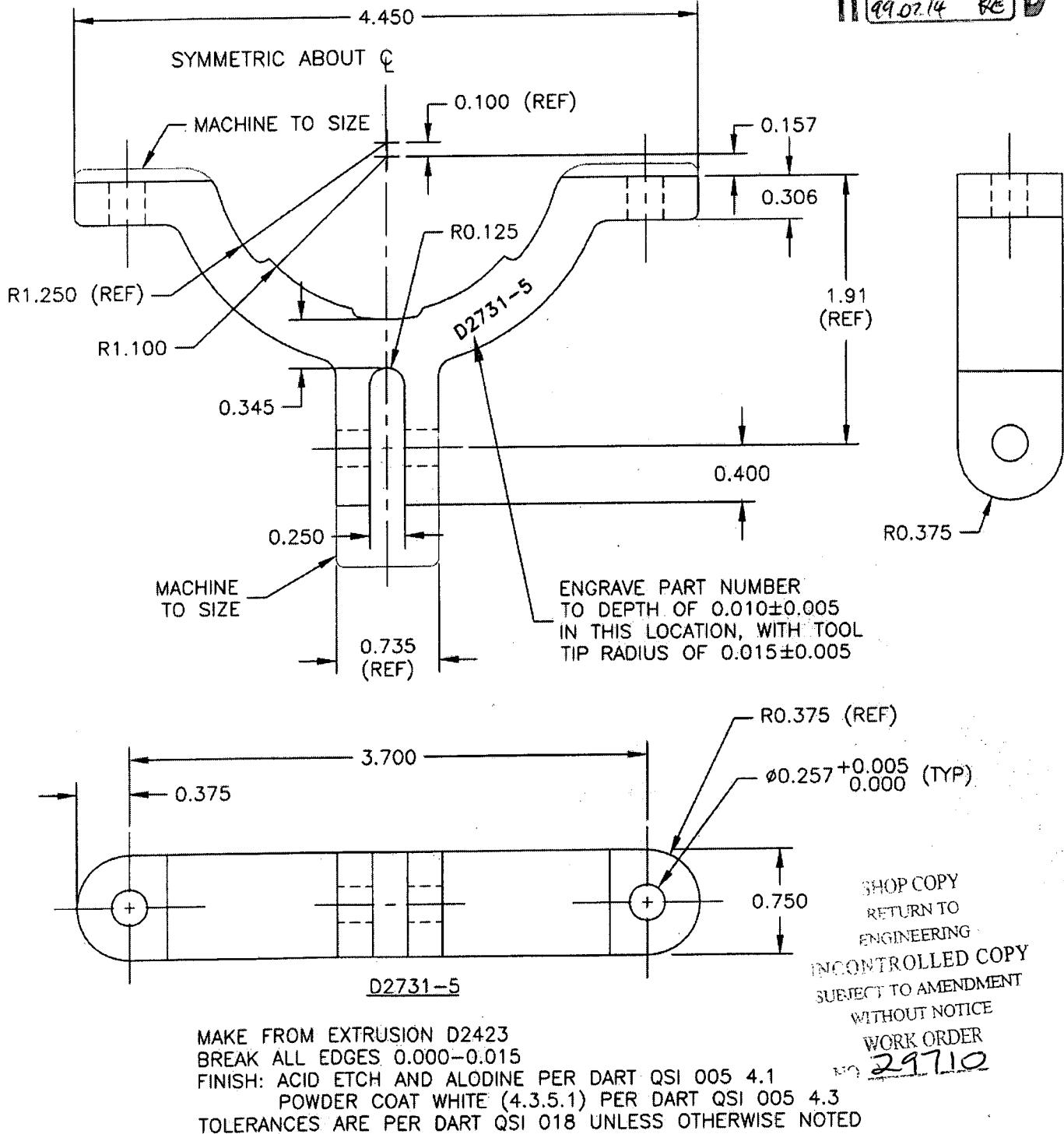
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WORK ORDER
NO. 29710



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CHECKED <i>KE</i>	APPROVED <i>JS</i>	DRAWING NO. D2731
DATE 99.07.06		TITLE MOUNTING LUG

REV. B
SHEET 3 OF 4
SCALE
1:1

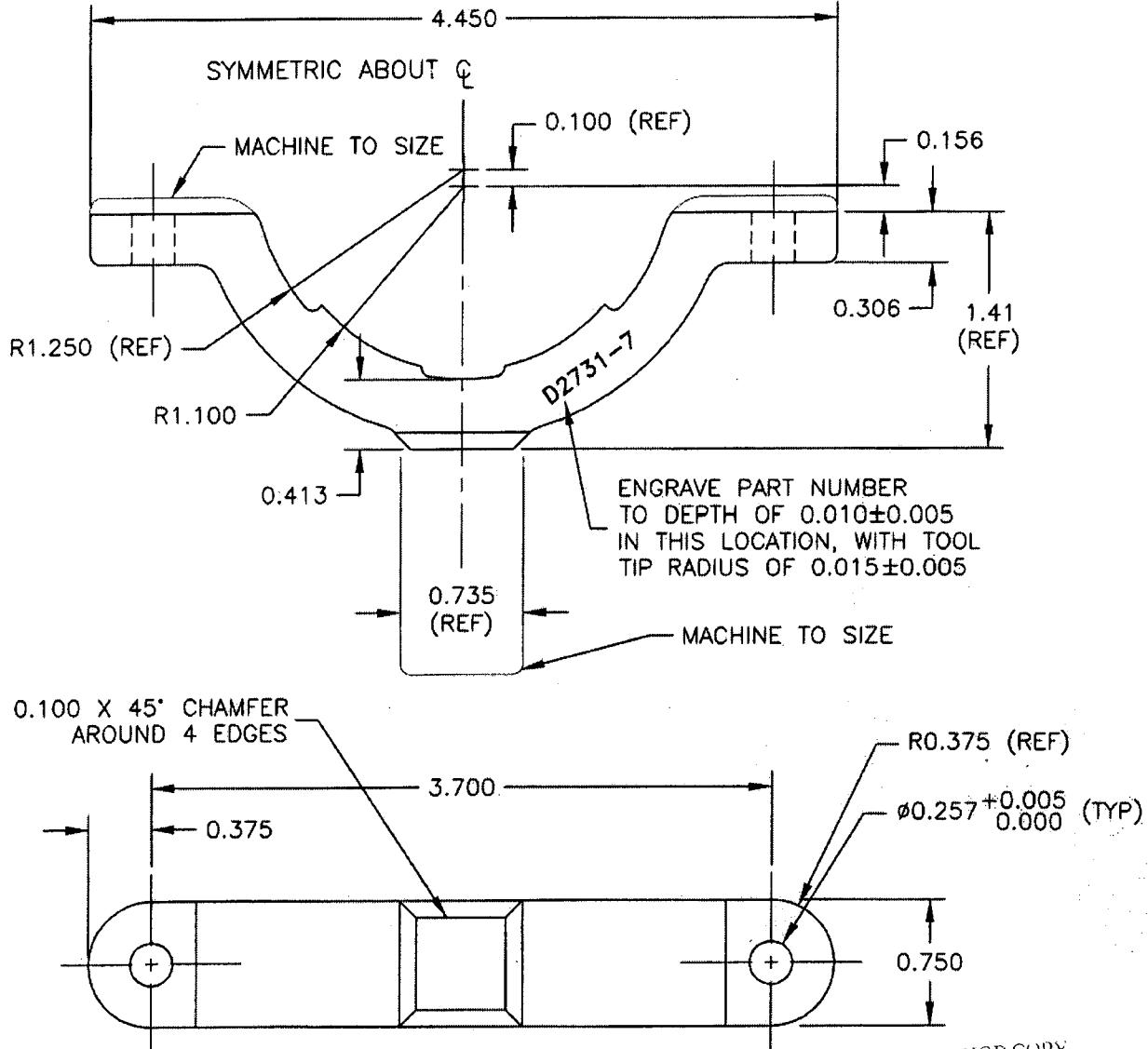
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99.07.14 *RC*



DART

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CHECKED <i>KE</i>	APPROVED <i>DS</i>	DRAWING NO. D2731
DATE 99.07.06		REV. B SHEET 4 OF 4 TITLE MOUNTING LUG SCALE 1:1

RELEASED
99.07.14 *KE*



MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER
NO. 29710



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

50

D2731-3

Lug B29710

2634

MATERIAL: supplied by DART D2423 B23779

01/01/24

We hereby certify that the above parts were made in conformance with applicable drawings.

Shig (Regula) Walz
METEC Metal Technology Inc.

Vankleek Hill, January 19, 2007

